User:

Tuesday, 18/12/2007 1:44:00 PM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 36431

Estimate Number

P.O. Number This Issue Prsht Rev.

First Issue

: 18/12/2007

S.O. No. : A

: SMALL /MED FAB

Previous Run Written By

Checked & Approved By

Comment

: Est. A, 07. 12/18

new issue

EC

Drawing Name

Part Number **Drawing Number**

Project Number **Drawing Revision**

Material **Due Date**

: CUP

: D30093 : D3009 UNDER RÉVIEW DK 457/12/19 : N/A

: 1)/× : 20/12/2007

07/12/19

Additional Product

Job Number:



Seg. #:

Machine Or Operation:

Description: Inventory

1.0

2.0

4.0

M304R1000

Comment: Qty.:

0.6035 f(s) 0.0503 f(s)/Unit Total:

1018 7/8 ROUND BAR

Material: AISI304/316 SS 1.00" Ø Round Bar

(M304R1000)

Batch: M 105 532 HARDINGE

HARDINGE CNC LATHE SMALL

Comment: 1-TURN AS PER FOLIO FA130 & DWG D3009

FOLIO REV: A DWG REV: ... B

y. A Park 07/12/19

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

2-DEBURR AS REQUIRED

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

OC8

SECOND CHECK

Comment: SECOND CHECK

PACKAGING '

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

4

Dar	t Α	ero	spa	ıce	Ltd
-----	-----	-----	-----	-----	-----

W/O:							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		-					
		·					
Part No):	PAR #: Fault Category:	NCR: Yes	s No DQ	A: <u></u>	_ Date: ₫	38/01/15
			QA:	N/C Close	d:	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	3	Verification	A	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
•											

NOTE: Date & initial all entries

Date:

Tuesday, 18/12/2007 1:44:00 PM

User:

. Linda Lacelle

Process Sheet

• Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 36431

Part Number: D30093

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2007/12/20

Dart Ae	rospace	Ltd							
W/O:			WC	RK ORDER CHANGE	S				· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PR	PROCEDURE CHANGE						Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A :	_ Date: _	
					QA: N	C Closed	d:	_ Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	ICE (NCR)			
The state of		Description of NC		Corrective Action Section	В	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section			QC Inspector
							į		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36431
Description: Cup	Part Number:	D30093
Inspection Dwg: D2009 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

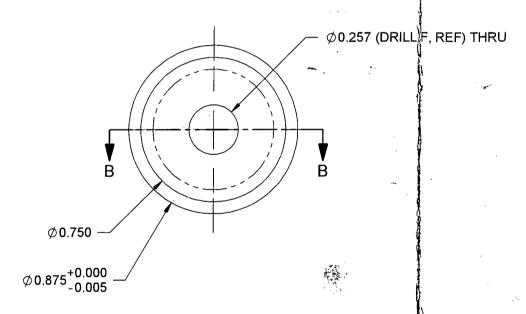
	X	First Article		Prototype
--	---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.353	1/- 0.010	-359	-			
0.094	+/-0.010	0.093				
0.063	+/- 0.010	-060				
\$ 0.254	+0.006/-0.001	. 258				
Ø 0.750	40.008/-0.001	8.750				
Ø 0.975	+0.0000/-0.005	0.872				
R G. 032 × 45°	+/-0.010	R 5:034 x 450				
R 0.042	+/- 0.010	R0.062				
			-			,
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	-		! 			
						, 4:
						·

Measured by:	y.A/		Audited by:	Sec.	Prototype Approval:	
		/19	Date:	07/12/19	Date:	

\[\]	Rev	Date	Change	Revised by KJ/RF	Approved
	Α		New Issue	NJ/Ni	L

R0.062 -R0.032 x 45° CHAMFER 0.094 0.063 **SECTION B-B** (REF)



DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN DRAWING NO. CHECKED REV. B D3009 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE DE APPR. DATE 07.12.12

COPYRIGHT © 2001 BY DART AEROSPACE LTD

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR (REF DART SPEC M304R)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.03 lbs

D3009-3 CUP

3

L Lacelle

From: Chris Provencal [cprovencal@dartaero.com]

Sent: January 14, 2008 10:08 AM

To: 'L Lacelle'
Subject: RE: d3009-3

You can make them, if that's what you're asking. The D135-692-041 kit is under review (not approved yet), but the parts are OK to make.

From: L Lacelle [mailto:llacelle@dartaero.com]

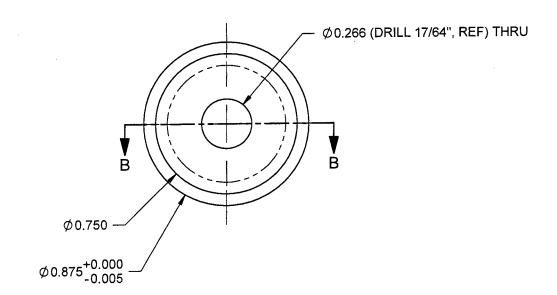
Sent: January 14, 2008 9:46 AM

To: Provencal, Chris **Subject:** d3009-3

Are they good now?

Thank You, Linda Lacelle Production Manager Dart Aerospace Ltd

R0.062 --R0.032 x 45° CHAMFER 0.094 -0.353 0.063 (REF) SECTION B-B



D3009-3 CUP

NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR (REF DART SPEC M304R)

D

- 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.03 lbs

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT
WITHOUT NOTICE



DESIGN (7)		DART AEROSPACE LTD		
DRAWN	001	HAWKESBURY, O	NTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. B	
MFG. APPR.	M	D3009	SHEET 2 OF 2	
APPROVED	-	TITLE	SCALE	
DE APPR.	-#-	CUP	2:1	
DATE 07.12.12		COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT MODITURE DEPRISON DECOM DATA PERSORPACE IN A PROPER A PERSON FOR THE MODITURE DEPRISON DECOM DATA PERSORPACE IN A PROPER DEPRISON DECOM DATA PERSORPACE IN A PROPERTY DEPRISON DECOM DATA PERSORPACE IN A PROPERTY DEPRISON DEPORTS OF THE PERSON DE		

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